

Work Order ID 61114

Friday, August 06, 2010 12:38:01 PM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/6/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 8/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 8-8-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2580 | Rev D | | | | | | | | |

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

8-10-08-04

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

IX 2 sub 10-08-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

(IX) 2 MB 10-08-19

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 - BE 10/08/23

| W/O: | | WORK ORDER CHANGES | | | | | |
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004.
A/R□□□ Aluminum Rod

M114877

BE 10/08/23

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

M114877

BE 10/08/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 10/08/24

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 QC Quality Control | QC10- Inspect visual per QSI004- ground welds Memo | 0.00 0.00 | | | | | | | |
| 160 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| 170 HandFinish Hand Finishing | Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution. | 0.00 0.00 | | | | | | | |

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**Setup Start**

Stop



Start Date: 8/6/2010 **Start Qty:** 1.00

Cust Item ID:

Required Date: 8/20/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Abstract

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

THE UNIVERSITY OF CHICAGO

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

m 115291

8:35

320

0.00

190

QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

11 10108124

① BK 20-8-26

1 0

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200 | | 0.00 | | | | | | | |
|  | Hand Finish | | | | | | | | |
| Hand Finishing | Memo | 0.00 | | | | | | | |
| | 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>M11517</u> Sikaflex expire date: <u>11/01</u> | | | | | | | | |
| | 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 | | | | | | | | |
| | 3-Inspect for foreign object per QSI 024 | | | | | | | | |
| | 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> <u>M11500</u> Sikaflex expire date: <u>11/01</u> | | | | | | | | |
| | 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: <u>A410028</u> | | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 210 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC Quality Control | Memo Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 | 0.00 | | | | | | | |
| 220 | Packaging | 0.00 | | | | | | | |
| Packaging Packaging | Memo Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: <u>PPP 60698</u> | 0.00 | | | | | | | |
| 230 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| QC Quality Control | Memo | 0.00 | | | | | | | C21018/30 |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID: 61114

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 8/6/2010

Required Date: 8/20/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD
 IPP Rev. O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2580-1  205 Skidtube bent detail | | Manufactured | No | | | 110 | Each | 4.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>LG</div> <div>1</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>57028</div> <div>1</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>ST046</div> <div>3</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>59856</div> <div>2</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>59913</div> <div>1</div> <div></div> </div> | | | | | | | | | | | | | |
| D2576-3  Step (maching detail) | | Manufactured | No | | | 140 | Each | 84.0000 | 1 | 1 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>LG</div> <div>84</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>46661</div> <div>36</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>52215</div> <div>48</div> <div></div> </div> | | | | | | | | | | | | | |
| D2579  Crossbolt Spacer | | Manufactured | No | | | 140 | Each | 327.0000 | 20 | 20 | | | |
| <div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div> | | | | | | | | | | | | | |
| <div> <div>LG</div> <div>327</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>57052</div> <div>5</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>57348</div> <div>4</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>58433</div> <div>2</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>59113</div> <div>182</div> <div></div> </div> | | | | | | | | | | | | | |
| <div> <div>60845</div> <div>134</div> <div></div> </div> | | | | | | | | | | | | | |

BS-61190 MB 10-08-19

BE 10/08/23

20 BE 10/08/23

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/20/2010

Start Qty: 1.00

Required Qty: 1.00

D2855

Manufactured No

200

Each

81.0000

1

1



Cap



Location

Loc Qty

Loc Code

FP6

1

56613

1

ST026

80

50513

1

50770

28

51539

2

53791

49

AN3-5A

Purchased No

200

Each

1,542.000

2

2



Bolt



Location

Loc Qty

Loc Code

ST350

1542

05057

542

115016

500

115371

500

AN960JD10L

NAS1149D0332J Purchased

No

200

Each

2,633.000

2

2



Washer



Location

Loc Qty

Loc Code

ST348

2633

110985

2633

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Shop Packet Print

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| W/O: | | WORK ORDER CHANGES | | | | | |
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Start Date: 8/6/2010

Required Date: 8/20/2010

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130

Purchased

No

200

Each

878.0000

50

50



Insert

Location

Loc Qty

Loc Code

FP

861

115079

861

ST282

17

11114723

x50 M 10/08/26

113238

17

AN3C4A

Purchased

No

200

Each

1,889.000

50

50



BOLT

Location

Loc Qty

Loc Code

ST350

1889

114108

14

114416

12

114523

2

114941

861

x50 M 10/08/26

115300

1000

AN960C10L

NAS1149C0332

Purchased

No

200

Each

29.0000

50

50



washer

Location

Loc Qty

Loc Code

ST245

29

107534

29

1115000

x50 M 10/08/26

Friday, August 06, 2010 12:38:05 PM

Shop Packet Print

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D3566-13

Manufactured No

200 Each

33.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP

2

53461

2

FP012

31

59661

23

60209

8

X1 JU 10/08/26

D3566-5

Manufactured No

200 Each

36.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP

22

60869

22

FP015

14

59158

14

X1 JU 10/08/26

D3566-1

Manufactured No

200 Each

30.0000

2

2



Gasket



Location

Loc Qty

Loc Code

FP

13

60857

13

FP015

17

57715

2

59126

3

60202

12

X2 JU 10/08/26

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 61114

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/20/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-11 Manufactured No

200 Each

8.0000

1 1



Wearshoe

Location

Loc Qty

Loc Code

FP019

8

59941

8

D3564-13 Manufactured No

200 Each

31.0000

1 1



Wearshoe

Location

Loc Qty

Loc Code

FP17

31

59660

19

60862

12

D3564-9 Manufactured No

200 Each

24.0000

1 1



Wearshoe

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

23

59201

10

60236

13

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 61114

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/6/2010

Required Date: 8/20/2010

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

27.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

1

34806

1

FP19

2

57525

1

58709

1

FP-19

24

59157

11

60868

13

D2594-3

Manufactured No

200

Each

379.0000

16

16



O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP

379

55546

19

58191

12

59358

348

D2594-1

Manufactured No

200

Each

419.0000

16

16



Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP

183

42807

112

55002

71

FP14

236

58434

47

59110

189

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2580 | REV. D SHEET 1 OF 3 |
| DATE 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |
| D | 07.02.27 | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | |

RELEASED
07-06-28 *[Signature]*

| QTY -041 | QTY -045 | Part Number | Description |
|-------------|-------------|---|-------------------|
| X | | D2580-041 | SKIDTUBE ASSEMBLY |
| | X | D2580-045 | SKIDTUBE ASSEMBLY |
| | | | |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 1 | 1 | D2576-3 | STEP |
| 20 | 24 | D2579 | CROSS BOLT SPACER |
| 16 | 16 | D2594-1 | PLUG |
| 16 | 16 | D2594-3 | O-RING |
| 1 | 1 | D2596 | 205 WEB |
| 1 | 1 | D2855 | AFT CAP |
| 1 | 1 | D3564-5 | WEARSHOE |
| 1 | 1 | D3564-9 | WEARSHOE |
| 1 | 1 | D3564-11 | WEARSHOE |
| 1 | 1 | D3564-13 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-13 | GASKET |
| | | | |
| 50 | 50 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130 | INSERT |
| 50 | 50 | AN3C4A | BOLT |
| 2 | 2 | AN3-5A | BOLT |
| 50 | 50 | AN960C10L | WASHER |
| 2 | 2 | AN960JD10L | WASHER |

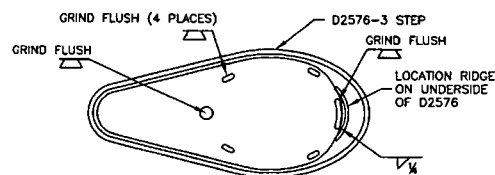
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *6444*
*RT 10-8-06***GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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DETAIL B
SCALE 5:24



Ø0.208

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

AN3-5A BOLT (1)
AN96Q/D10L WASHER (1)
(2 PLACES)

D2855 CAP

0.40

SEAL WITH
SIKAFLEX-241/-291

Diagram illustrating the assembly of a wheel component. The diagram shows a cross-section of a wheel with a central hub and spokes. The components are labeled as follows:

- D2579 SPACER
- D2596 WEB (REF)
- ALS7-1032-130 (REF) (TYP 50 PLACES)

Assembly steps are listed on the right:

1. CHA
2. INS
3. WEL
4. C'B

After PERFORM

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50
DISTANCE TO AFT END
OF D2598 WEB
3 7
1.750 1.750
0.508 (TYP.)
(40 PLACES)
REFER TO DETAIL A
REFER TO DETAIL A
8.750
17.375
26.000
34.188
57.313 (REF.)
7 EQUAL SPACES
8.188 PITCH
38.0
91.500
190.0
(D2500-1)

WELD AS PER DETAIL B

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

0.5 1.5 1.5 D

8

1.5 1.5 1.5

P P P P P P P

REFER TO DETAIL C

D3566-1 D3566-5 D3566-1 D3566-13

D3564-11 D3564-5 D3564-9 D3564-13

AN3C4A BOLT (1)
AN560C10L WASHER (1)
(50 PLACES)

DESIGN J DRAWN BY

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| | | | |
|----------|--------------------|----------|--------------------|
| DESIGN | <i>[Signature]</i> | DRAWN BY | <i>[Signature]</i> |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> |
| DATE | | | |
| 07.02.27 | | | |

| | |
|--------------------------------|------------------------|
| DRAWING NO. D2580 | REV. D SHEET 2 OF 3 |
| TITLE 205 SKIDTUBE ASSEMBLY | SCALE 1:24 |

Diagram illustrating the grinding locations for the propeller cross-section:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- LOCATION RIDGE ON UNDERSIDE OF D2576

Diagram illustrating the location of the D2855 cap and the AN3-5A bolt on the aft fuselage bulkhead. The diagram shows the cap and bolt assembly, with labels indicating the required drilling and sealing steps.

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- AN3-5A BOLT (1)
- AN950/D10L WASHER (1) (2 PLACES)
- D2855 CAP
- SEAL WITH SIKAFLEX-241/-291
- SEE NOTE ii)
- 0.40

Diagram of a wheel assembly with labels: D2579 SPACER, D2596 WEB (REF), ALS7-1032-130 (REF) (TYP 50 PLACES), and AFTER PERFORM 1. CHA 2. INSU 3. WEL 4. C'B.

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

[illegible][illegible][illegible]

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DATE
07.02.27

10

| TITLE | SCALE |
|-----------------------|-------|
| 205 SKIDTUBE ASSEMBLY | 1:24 |

NO. 232

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 59105
Part number: D205-634-041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dunn Date of Test Coupon 10.06.01
Welder Barclay Elliott Date of Test Coupon 10.06.01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld